



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRELIMINARY ISSUE

D5611-1

Job Sheet 183490

Accounting Job RD17-1048-01



Part No: D5611-1

Job Qty: 1 ea

Part Name: EC130 Skidtube



Part Weight: 0 lbs

Status: Scheduled

Job Created: 9/19/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: D5611 REVA.10 IPP REV:A 18.06.20 NEW ISSUE DD VERF:JFS

Ship Via:

POSITIVE RECALL

EFFECTIVE 19/09/18 AUTH 21

RELEASED 9 DATE 16/10/18

Priority: Medium

@ Rev A
ECUB-81

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	1 pcs	9/28/18	9/28/18	0.00	0.00	Purchasing		SEP 19 2018
120	Packaging	1 pcs	9/28/18	9/28/18	0.00	0.00	Packaging2		SEP 19 2018
130	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC6		38
140	Packaging	1 pcs	9/28/18	9/28/18	0.00	0.00	Packaging3-1		7:39
150	QC21-FG	1 Ea	9/28/18	9/28/18	0.00	0.00	QC21		21 SEP 26 2018

Part Op 110 - Issue P/O to Parker Fab: 040303. Manufacture D5611-1 as per dwg (Bend,Swag, Remove excess material
Descriptions: after bending) **Ship extrusion D6031-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO
PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE
FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required
120 - Ensure material release note is attached

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6031-120	Tube, Seamless	1 Ea (1 ea)	110-Purchasing	5111361
D5611-1P	EC130 Skidtube	1 pcs (1 ea)	120-Packaging	5111359

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D6031-120	1	40	0
120-Packaging	D5611-1P	1	0	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ould not be found.

Plex 9/19/18 7:44 AM Dart.lajeunesse.marie

Container No: S111362



Part: D5611-1

Job No: 183490

Serial No/Batch: S111362

Revision: A10

Inspector:

Exp Date:

Instructions:

Date: 09/19/18

DQA: _____ Date: _____

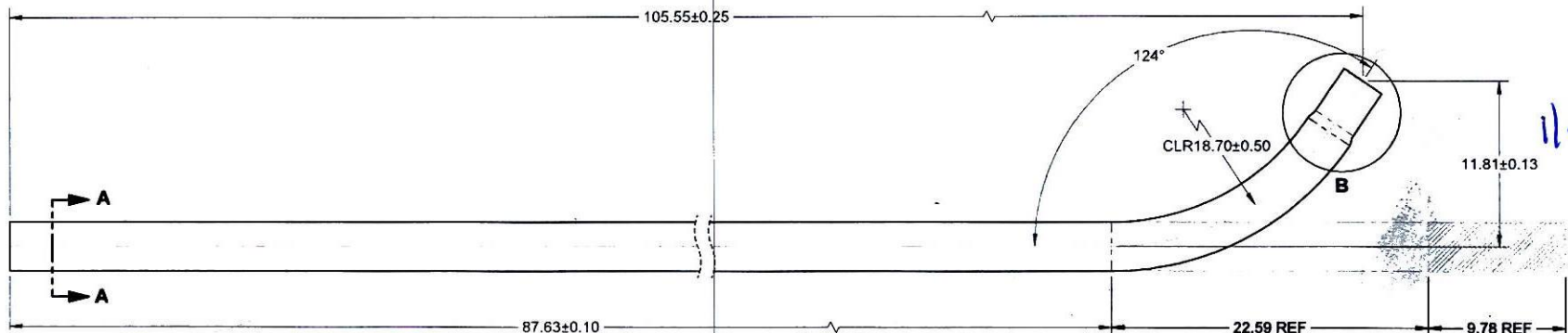


WORK ORDER NON-CONFORMANCE / UPDATE

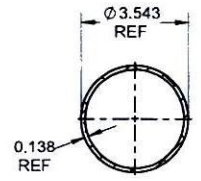
QA Closed: _____ Date: _____

Work Order update only ☐

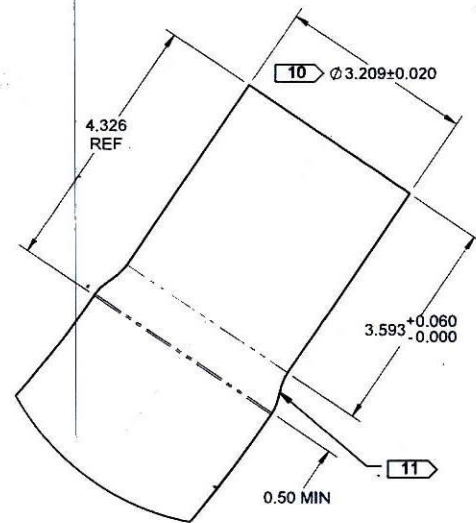
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



D5611-1 EC130 SKIDTUBE



SECTION A-A
SCALE 2X



DETAIL B
SCALE 4X

NOTES:

- 1) MATERIAL: MAKE FROM D6031-120
STRAIGHT LENGTH = 120.00" (BEFORE BENDING / TRIMMING)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 16.41lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.
- 10) SWAGE 3.593 +0.060/-0.000 AT THE BENT END OF THE TUBE TO Ø3.209±0.020
- 11) SWAGED TRANSITION MUST BE SMOOTH, GRADUAL, AND WITHOUT VISIBLE DISCONTINUITIES

11.875

Accepted by
No

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1834920 v05
18-05-13

PRELIMINARY ISSUE

A NEW ISSUE		ZF	18.05.07
REV.	DESCRIPTION	BY	DATE
DESIGN	NO		
DRAWN	ZF		
CHECKED	NO		
MFG. APPR.	DP		
APPROVED			
DE APPR.			
DATE	18.05.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5611** REV. A10
TITLE **EC130 SKIDTUBE** SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040303**

Supplier: PAR005-VU
Parker Fabrication Inc
501 East Courtland
Morton, IL 61550-9043 USA
Phone: 309-266-8413
Fax: 309-266-7231

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040303
PO Date: 6/22/18
Due Date: 9/21/18
Purchase Order Revision: 2
Revision Date: 9/13/18
Ship-To Contact: Hemmerich, Steven
Phone: 613-632-5200 Ext: 281
shemmerich@dartaero.com
Pynt Terms: Net 30
Freight Terms: Collect
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		D5611-1P			EC130 Skidtube First Article Inspection. Expedite charges included in price. Forward quality docs to buyer prior to shipment	Firmed	-	9/21/18	1 pcs	0 pcs	1 pcs	\$502.75/pcs	\$502.75
					w/o183493								

1 X SEP 19 2018

Line Item Note Advance notice required for Quality audit.

1 X	SEP 19 2018	w/o183486	Firmed	-	9/21/18	1 pcs	0 pcs	1 pcs	\$502.75/pcs	\$502.75
1 X	SEP 19 2018	w/o183487	Firmed	-	9/21/18	1 pcs	0 pcs	1 pcs	\$502.75/pcs	\$502.75
1 X	SEP 19 2018	w/o183488	Firmed	-	9/21/18	1 pcs	0 pcs	1 pcs	\$502.75/pcs	\$502.75
1 X	SEP 19 2018	w/o183489	Firmed	-	9/21/18	1 pcs	0 pcs	1 pcs	\$502.75/pcs	\$502.75
1 X	SEP 19 2018	w/o183490	Firmed	-	9/21/18	1 pcs	0 pcs	1 pcs	\$502.75/pcs	\$502.75
1 X	SEP 19 2018	w/o183491	Firmed	-	9/21/18	1 pcs	0 pcs	1 pcs	\$502.75/pcs	\$502.75
1 X	SEP 19 2018	w/o183492	Firmed	-	9/21/18	1 pcs	0 pcs	1 pcs	\$502.75/pcs	\$502.75

Sub Total: 8 0 8 \$4,022.00

Grand Total: \$4,022.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/19/18 8:08 AM dart.hemmerich.steven



Parker Fabrication, Inc.
501 East Courtland
Morton, IL 61550-9043

Ph: 309.266.8413

Fax: 309.266.7231

st 2
Pack List

Number: **119663**

Date: 17-Sep-18

To
Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A 1K7
Canada

Ship To

Steven Hemmerich
Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A 1K7
Canada

Ph: 1 613 632-5200

Ph: 1 613 632-5200

Terms		Ship Via	
		Freight Collect	
Quantity	Description	Rev:	
8 ea	Part: EC130SKID EC130 Skidtube rev. A10 SO: 69748	PO: PO040303	Line: 001
4 ca	Part: EC130FWD EC130 Fwd X Tube rev. A9 SO: 69748	PO: PO040303	Line: 002
Thank you for your business!			

D/S
38
9-88



Certificate of Conformance (CoC)

Form F-4003
Page 1 of 1
Last Revised:
3/09/2018

Supplier Name: Parker Fabrication
Supplier Number: _____
Part Description: EC130 Skidtube

Part Number: D5611
Drawing Number: D5611 Revision: A10

Purchase Order #: PO040303
Quantity: 8
Serial Number(s): 207294 (if applicable)
Lot/Heat Number: S078761 (if applicable)

All technical requirements of the contract are satisfied. Quality and performance are in accordance with the contract, the specifications, and all references and associated contractual drawings and documents.

I, as a supplier to Dart Aerospace LTD, acknowledge and certify the material covered under this document is produced in accordance with the following:

- ☒ All Contractual "Flow Down" Requirements
- ☒ Supplier Standards Guide
- ☒ Global Supplier Quality Manual
- ☒ Product Conformance
- ☒ Free of Counterfeit Material

(Acknowledge by marking the boxes)


Signature

Quality Manager
Title

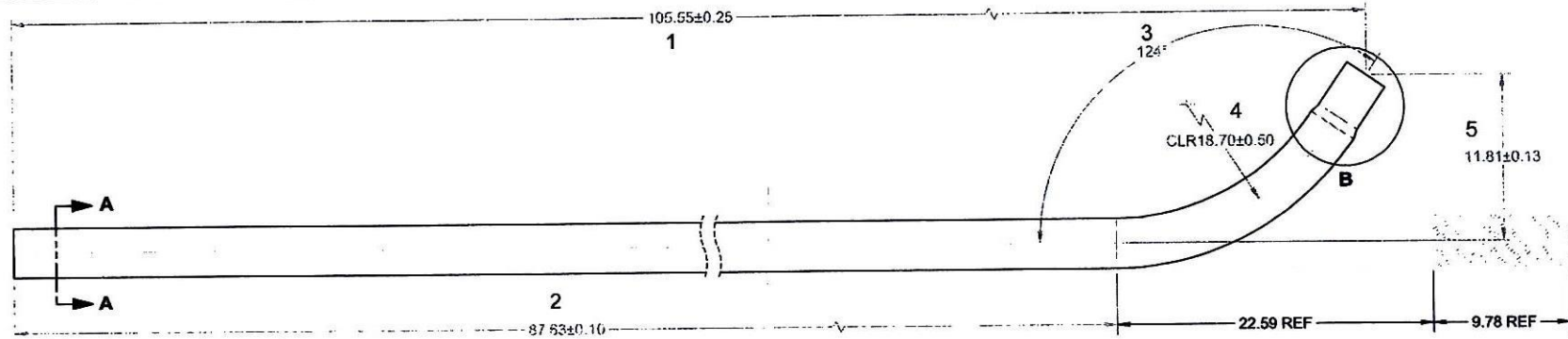
9/17/2018
Completion Date

DAS
38
9-89

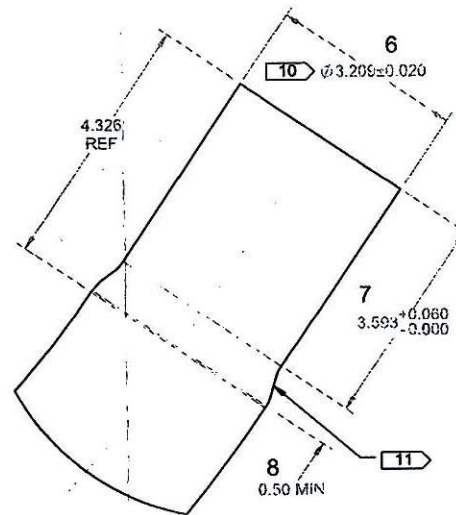
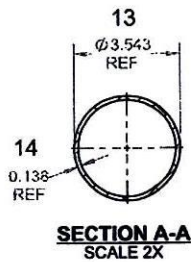
This certifies the parts/items/materials identified above conform to all applicable drawings and/or specifications as evidenced by reports or other documentation on file and all other purchase order and quality requirements have been met.

Production Part Approval Dimensional Test Results

[illegible]



D5611-1 EC130 SKIDTUBE



DETAIL B
SCALE 4X

NOTES:

- 1) MATERIAL: MAKE FROM D6031-120
STRAIGHT LENGTH = 120.00" (BEFORE BENDING / TRIMMING)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 16.41lbs
- 10) 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) 9) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.
- 12) 10) SWAGE 3.593 +0.060/-0.000 AT THE BENT END OF THE TUBE TO $\phi 3.209 \pm 0.020$
- 13) 11) SWAGED TRANSITION MUST BE SMOOTH, GRADUAL, AND WITHOUT VISIBLE DISCONTINUITIES

PRELIMINARY ISSUE

A		NEW ISSUE		ZF	18.05.07
REV.		DESCRIPTION		BY	DATE
DESIGN	NO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	ZF				
CHECKED	NO	DRAWING NO. D5611			REV. A10
MFG. APPR.	DP				SHEET 1 OF 1
APPROVED		TITLE EC130 SKIDTUBE			SCALE
DE APPR.					NTS
DATE	18.05.07	COPYRIGHT © 2018 BY DART AEROSPACE LTD (THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR THE COMMUNICATION OF ANY OTHER MESSAGE WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD)			

Entered: _____ Date: _____

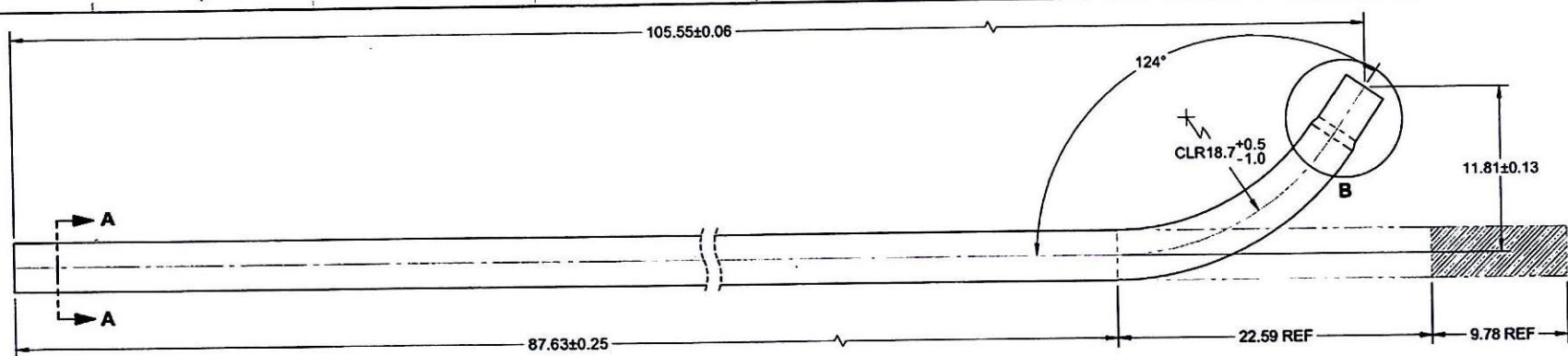


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

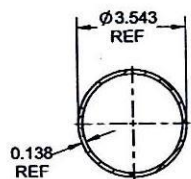
NCR No. _____

Route update only ☐

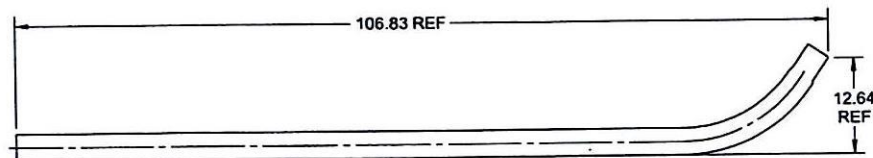
Job: <u>183490</u> Part No. <u>D5611-1</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☒		
Date: <u>18-10-26</u>	Sequence #: <u>130</u>	QTY Affected: <u>①</u>	MRB (QSI042) <u>INSP</u> <u>12</u> <u>9/18/10/25</u>	
Description Work Order Deviation <u>D5611-1 was supplied unfired, both aft and fwd ends</u> <u>Swage OD is out of tolerance due to design change after manufacture</u>		Disposition <u>FBI deviations are due to lack of trimming, part will be trimmed on next WO</u> <u>Acceptable</u> <u>Swage O.D. is acceptable</u> <u>No effect on over geometry or stiffness of assembly</u>		Completed By <u>INSP</u> <u>12</u> <u>9/18/10/25</u> Lead hand / Supervisor <u>DAS</u> <u>9</u> <u>9-89</u> <u>18-10-26</u>
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				



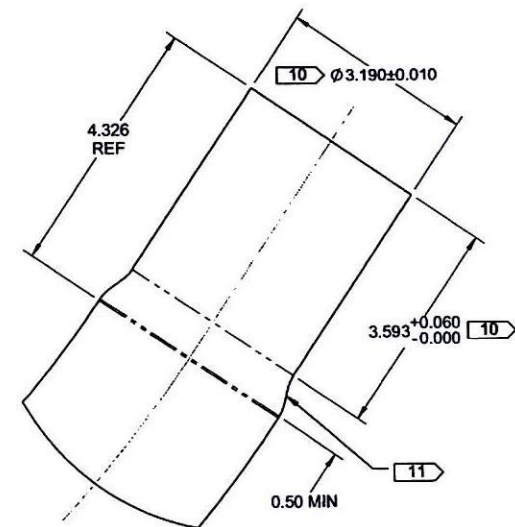
D5611-1 SKIDTUBE (EC130)



SECTION A-A
SCALE 2X



AUXILIARY VIEW
SCALE 0.5X



DETAIL B
SCALE 4X

RELEASED
2018 OCT 02
ECN 14-817

NOTES:

- 1) MATERIAL: MAKE FROM D6031-120
STRAIGHT LENGTH = 120.00" (BEFORE BENDING / TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT EXTRUSION PER DART QSI 005 4.1 PRIOR TO SENDING EXTRUSION TO OUTSIDE VENDOR
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 16.40 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.
- 10) SWAGE 3.593+0.060/-0.000 LENGTH AT THE BENT END OF THE TUBE TO Ø3.190±0.010
- 11) SWAGED TRANSITION MUST BE SMOOTH, GRADUAL, AND WITHOUT VISIBLE DISCONTINUITIES

APPROVED

A		NEW ISSUE		ZF	18.05.07
REV.	DESCRIPTION			BY	DATE
DESIGN	NO	DART AEROSPACE LTD			
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	MW	DRAWING NO.	REV. A		
MFG. APPR.	JFS	D5611	SHEET 1 OF 1		
APPROVED	NO	TITLE	SCALE		
DE APPR.	CP	SKIDTUBE (EC130)	NTS		
DATE	18.05.07		COPYRIGHT © 2018 BY DART AEROSPACE LTD		
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